

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001357**Date Inspected:** 03-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi & Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 89 Meter Mock-Up**Summary of Items Observed:**

General

This Quality Assurance Inspector oversaw Quality Assurance Inspectors Paul Stovall, Scott Croff and Joe Lanz performing fabrication inspection out on the shop floor today. Mr. Stovall observed welding operations in bay 2 on the 77, 89 and 114 Meter Mock-Ups. Grinding was being performed on the 77 Meter Mock-Up while some welding was carried out on the 89 Meter Mock-up. Slag indications were observed by Mr. Stovall on the 114 Meter Mock-up and marked for removal. Mr. Lanz observed complete joint penetration welding on FB008-05-043 and tack welding on FB021-01-079. Mr. Lanz further performed ultrasonic testing on SP021-01-002, SP029-01-002, FB004-02-042 & FB013-04-42 reporting class A indications all welds with exception to FB004-02-042. He further measured and recorded the Y location for samples on the deck welding trial. Mr. Croff observed in bay 3 the tack welding of various stiffeners on the Side Plates and fillet welding of a Bottom Plate BP002-01 on the gantry. The gantry was observed becoming stuck on an object which caused some weld puddles to occur.

**89 Meter Mock-Up**

This Quality Assurance Inspector observed Zhenhua Port Machinery Company Welder Lei Li Chao, welder identification 053619 welding on MUSB-MA26-30 with welding procedure WPS-B-T-2232-TC-U5F with the flux core arc welding procedure. Some of the essential welding variables were checked and found to be as follows; Preheat 136° Celsius, 30.9 volts, 310 for the amperage and the travel speed was 308 millimeters per minute.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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### Summary of Conversations:

No conversations held today.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Berger,Bruce
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Cochran,Jim
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QA Reviewer
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